

Date: Friday, 29/08/2008 1:34:25 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|----------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | FLOAT SKIDTUBE |
| Job Number : | 41690 | | |
| Estimate Number : | 10366 | | |
| P.O. Number : | | Part Number : | D412742013 |
| This Issue : | 29/08/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | N/A |
| First Issue : | 29/08/2008 | Project Number : | N/A |
| Previous Run : | 41689 | Drawing Revision : | D |
| | Type : | Material : | |
| | SKIDTUBES | Due Date : | 10/09/2008 |
| Written By : | | Qty: | 1 Um: Each |
| Checked & Approved By : | <u>JUL 08.8.29</u> | | |
| Comment : | Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM Est Rev: C 07-12-03 ECN 1072 DD verified by: JLM | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Sub 08.9.11



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 - CHG004

CHG005

| | | |
|-----|--------|---------------------|
| 2.0 | 41690A | FLOAT SKID ASSEMBLY |
|-----|--------|---------------------|



Comment: Sub-Component FLOAT SKID ASSEMBLY

1 x D412-742-043 Batch 41690A

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

| | | |
|-----|-------|---------------------|
| 4.0 | D2571 | Saddle, Fwd Out 205 |
|-----|-------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside

41703

JS 08/09/26 (K)

| | | |
|-----|-------|--------------------|
| 5.0 | D2572 | Saddle, Fwd In 205 |
|-----|-------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside

41704

JS 08/09/26 (K)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------|---------------------|
| 6.0 | D2573 | Saddle, Aft Out 205 |
|-----|-------|---------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------------|-------|
| 1 | D2573 | Saddle Aft Outside | 40516 |

JS 08/09/26 (X)

| | | |
|-----|-------|--------------------|
| 7.0 | D2574 | Saddle, Aft In 205 |
|-----|-------|--------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|--------------------|-------|
| 1 | D2574 | Saddle Aft Outside | 41706 |

JS 08/09/26 (X)

| | | |
|-----|-------|---------------|
| 8.0 | D2876 | Saddle Spacer |
|-----|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|-------|
| 2 | D2876 | Saddle Spacer | 38662 |

JS 08/09/26 (X)

| | | |
|-----|-------|---------------|
| 9.0 | D2877 | Saddle Spacer |
|-----|-------|---------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|---------------|-------|
| 2 | D2877 | Saddle Spacer | 39128 |

JS 08/09/26 (X)

| | | |
|------|--------|---------|
| 10.0 | D34031 | Bushing |
|------|--------|---------|



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|--------|
| 16 | D3403-1 | Bushing | B39984 |

JS 08/09/26 (X)

| | | |
|------|-------|-----------|
| 11.0 | D2747 | Set Screw |
|------|-------|-----------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 4 | D2747 | Bolt | 41599 |

JS 08/09/26 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|--------|-----------|
| 12.0 | D35331 | Set Screw |
|------|--------|-----------|



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)
Set Screw

41 606

JS 08/09/26 (X)

| | | |
|------|--------|------|
| 13.0 | AN4C6A | Bolt |
|------|--------|------|



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)
Pick:

| Qty Part Number | Description | Batch |
|-----------------|-------------|---------|
| 16 AN4C6A | Bolt | M167242 |

JS 08/09/26 (X)

| | | |
|------|---------|------|
| 14.0 | AN4C52A | BOLT |
|------|---------|------|



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

| Qty Part Number | Description | Batch |
|-----------------|-------------|---------|
| 8 AN4C52A | Bolt | M105423 |

JS 08/09/26 (X)

| | | |
|------|---------|------|
| 15.0 | AN6C12A | BOLT |
|------|---------|------|



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
Pick:

| Qty Part Number | Description | Batch |
|-----------------|-------------|---------|
| 8 AN6C12A | Bolt | M104289 |

JS 08/09/26 (X)

| | | |
|------|--------|-----------------|
| 16.0 | D36723 | Phenolic Washer |
|------|--------|-----------------|



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)
PHENOLIC WASHER

37374

JS 08/09/26 (X)

| | | |
|------|------------|--------|
| 17.0 | AN960C416L | WASHER |
|------|------------|--------|



Comment: Qty.: 32.0000 Each(s)/Unit Total: 32.0000 Each(s)
WASHER

M16 8558 x16 M168672 x16

JS 08/09/26 (X)

| | | |
|------|--------|-----------------|
| 18.0 | D36729 | Phenolic Washer |
|------|--------|-----------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)
PHENOLIC WASHER

35523

JS 08/09/26 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

WASHER

M108672

JS 08/09/26 (X)

20.0

D367211

Phenolic Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

PHENOLIC WASHER

B35524

JS 08/09/26 (X)

21.0

MS210434

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

Nut

M109148

JS 08/09/26 (X)

22.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch:

M108119

JS 08/09/26 (X)

23.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

B40528
B39130 X

JS 08/09/26 (X)

24.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

35779

JS 08/09/26 (X)

25.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

31841

JS 08/09/26 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

M101467

SS 08/09/20 (X)

27.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

M109148

SS 08/09/20 (X)

28.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

40529

SS 08/09/20 (X)

29.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

B33519 X1 39732 x1

SS 08/09/20 (X)

30.0

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

40285

SS 08/09/20 (X)

31.0

AN3C37A

BOLT



Comment: Qty.: 1.0000 EACH(s)/Unit Total : 1.0000 EACH(s)

BOLT

M109169

SS 08/09/20 (X)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|------|---------|------|
| 32.0 | AN3C40A | BOLT |
|------|---------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

SS 08/09/26 (XU)

| | | |
|------|---------|------|
| 33.0 | AN3C41A | BOLT |
|------|---------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M108084

SS 08/09/26 (XU)

| | | |
|------|---------|------|
| 34.0 | AN3C42A | BOLT |
|------|---------|------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BOLT M106169

SS 08/09/26 (XU)

| | | |
|------|---------|------|
| 35.0 | AN3C43A | BOLT |
|------|---------|------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
BOLT 106227

SS 08/09/26 (XU)

| | | |
|------|---------|------|
| 36.0 | AN3C46A | BOLT |
|------|---------|------|



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
BOLT M106169

SS 08/09/26 (XU)

| | | |
|------|-----------|--------|
| 37.0 | AN960C10L | washer |
|------|-----------|--------|



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)
washer M109282

SS 08/09/26 (XU)

| | | |
|------|----------|-----|
| 38.0 | MS210433 | Nut |
|------|----------|-----|



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Nut M109147

SS 08/09/26 (XU)

| | | |
|------|-----|------------------------------------|
| 39.0 | QC4 | INSPECT 100% KITS FOR COMPLETENESS |
|------|-----|------------------------------------|



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/09/30 (XU)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:25 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 41690

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location: _____

8/10/01 (1)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 68-10-02

41690A

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:39 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|---------------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | FLOAT SKID ASSEMBLY |
| Job Number : | 41690A | | |
| Estimate Number : | 10756 | | |
| P.O. Number : | | Part Number : | D412742043 |
| This Issue : | 29/08/2008 | Drawing Number : | D3391 |
| Prsht Rev. : | NC | Project Number : | N/A |
| First Issue : | 29/08/2008 | Drawing Revision : | G |
| Previous Run : | 41689A | Material : | |
| Written By : | | Due Date : | 10/09/2008 |
| Checked & Approved By : | JUL 08.8.09 | Qty: | 1 Um: Each |
| Comment : | Est Rev A 05.10.13 New Issue KJ/JLM Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC Est Rev:C 07-05-28 As per Rev F JLM Est Rev:D 07-12-04 ECN 1072 DD verified by:JLM | | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|

**Comment:** DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

N/A HJ

| | | |
|-----|-----------------|----------------------------|
| 2.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
|-----|-----------------|----------------------------|

**Comment:** HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 M107712

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291 M108801

Expiry date: 08/10

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex exept ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R LPS Procyon M104251

A/R Sikaflex-241/-291 M108801

Expiry date: 08/10

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

FD 08/09/25 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 41690A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

D3391023

Mid Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-023 Mid Tube Assembly

B41747

FZ

4.0

D3391025

Aft Tube Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty Part Number Description

Batch

1 D3391-025 Aft Tube Assembly

B41190

FZ

5.0

D35641

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch:

B40988

FZ

6.0

D35661

Gasket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch:

B41915

FZ

7.0

D35643

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B40530

FZ

8.0

D35645

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

B41464

FZ 08/09/25 (1)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 41690A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

D35665

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GASKET

Batch: 641467

FL

10.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total: 24.0000 Each(s)

BOLT

Batch: m 109061

FL

11.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

BOLT

Batch: m 108880

FL

12.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

BOLT

Batch: m 107376

FL

13.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: m 108928

FL 08/09/25

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/09/09

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: PPP

PPP Rev: 8/9/30

4x

SD

41690 C

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 29/08/2008 1:34:39 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 41690A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8.10.02

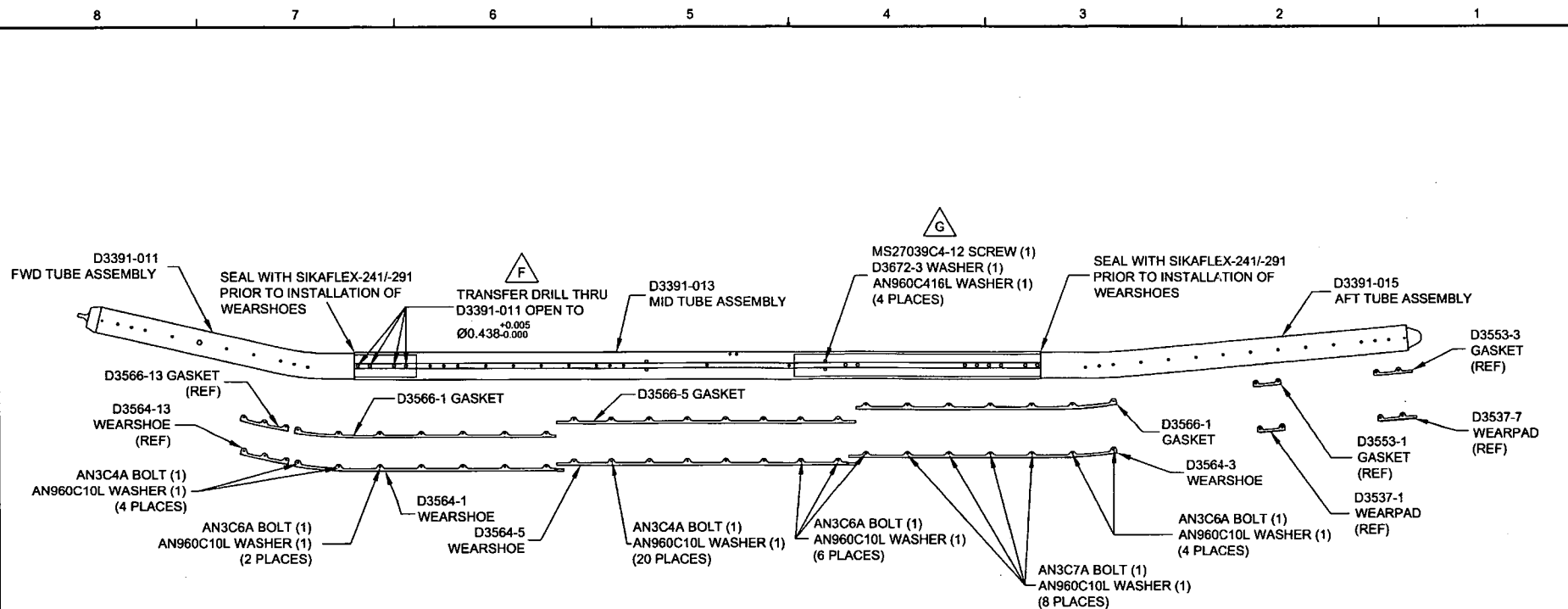
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|--------------|-------------------------|
| 1 | D3391-041 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-011 | FWD TUBE ASSEMBLY |
| 1 | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D3391-015 | AFT TUBE ASSEMBLY |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 4 | D3672-3 | WASHER |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 8 | AN3C7A | BOLT |
| 44 | AN960C416L | WASHER |
| 4 | MS27039C4-12 | SCREW |
| 4 | AN960C416L | WASHER |

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

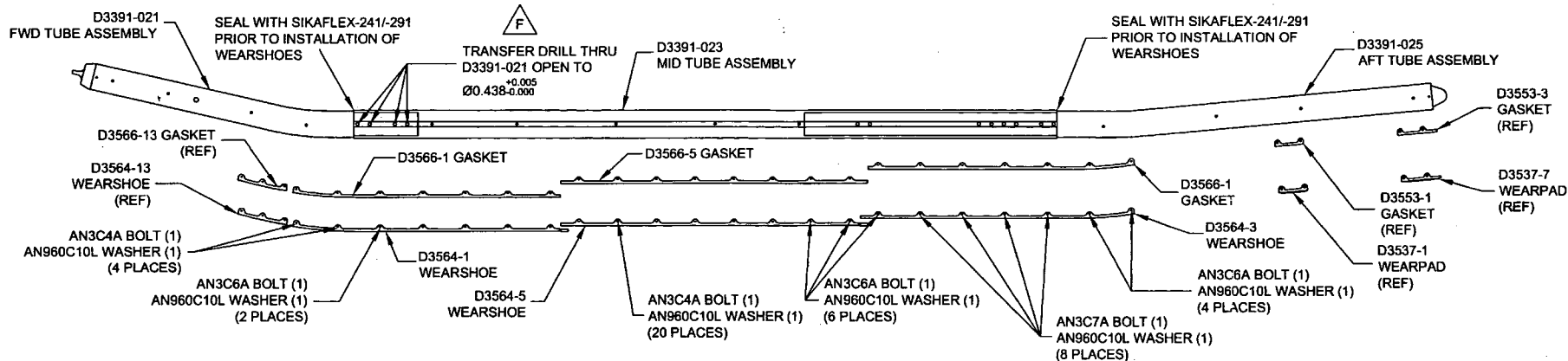
| | | | |
|------------|---|----|----------|
| G | REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY | DC | 07.07.31 |
| F | ADD SS WEARSHOE, GASKET REMOVE FWJ SADDLE HOLE -011-021 | PH | 07.01.18 |
| E | CHANGE TOLERANCE, EASE MANUFACTURE | PH | 06.04.25 |
| D | UPDATE TOLERANCE, CHANGE HOLE SIZE | PH | 06.01.23 |
| C | LENGTHEN AFT EXTENSION | PH | 05.09.27 |
| B | DRAWING UPDATES | PH | 05.06.10 |
| A | NEW ISSUE | PH | 05.02.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 07.07.31 | | |

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3391
REV. G
SHEET 1 OF 8
TITLE 412 FLOAT SKIDTUBE
SCALE NTS

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D3391-043 ASSEMBLY

RELEASED
07.11.04

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

| QTY | PART NUMBER | DESCRIPTION |
|-----|-------------|-------------------------|
| X | D3391-043 | FLOAT SKIDTUBE ASSEMBLY |
| 1 | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | D3564-1 | WEARSHOE |
| 1 | D3564-3 | WEARSHOE |
| 1 | D3564-5 | WEARSHOE |
| 2 | D3566-1 | GASKET |
| 1 | D3566-5 | GASKET |
| 24 | AN3C4A | BOLT |
| 12 | AN3C6A | BOLT |
| 8 | AN3C7A | BOLT |
| 44 | AN960C10L | WASHER |

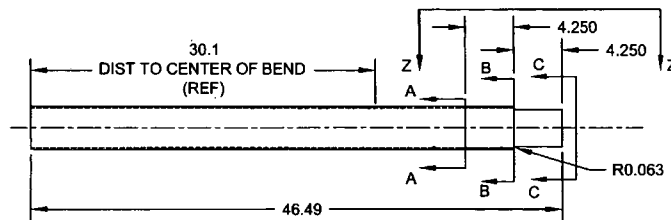
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

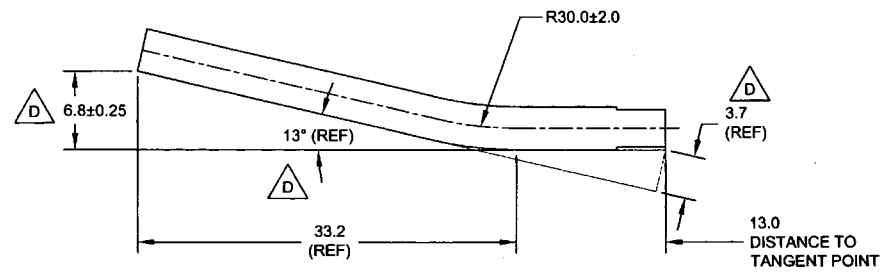
| | | |
|------------|------------|---|
| DESIGN | <i>PH</i> | DART AEROSPACE USA, INC |
| DRAWN | <i>JLC</i> | PORT HADLOCK, WA |
| CHECKED | <i>J</i> | DRAWING NO. REV. G |
| MFG. APPR. | <i>JP</i> | D3391 SHEET 2 OF 8 |
| APPROVED | <i>PH</i> | TITLE SCALE |
| DE APPR. | <i>PH</i> | 412 FLOAT SKIDTUBE NTS |
| DATE | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC |

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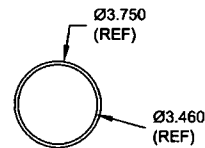
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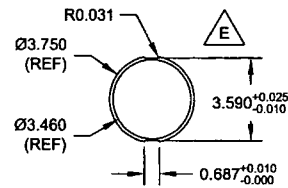
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



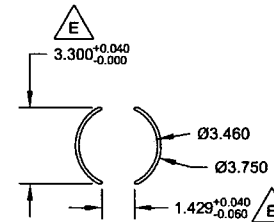
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



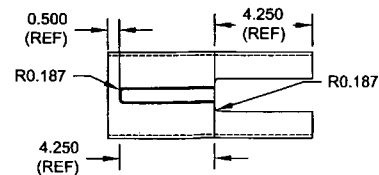
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

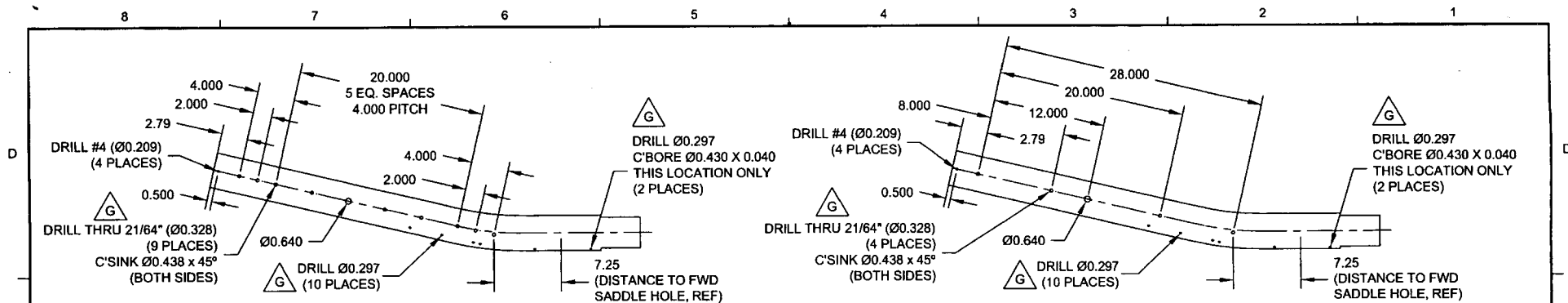


VIEW Z-Z
(SCALE 1:5)

RELEASED
07-11-06 MP

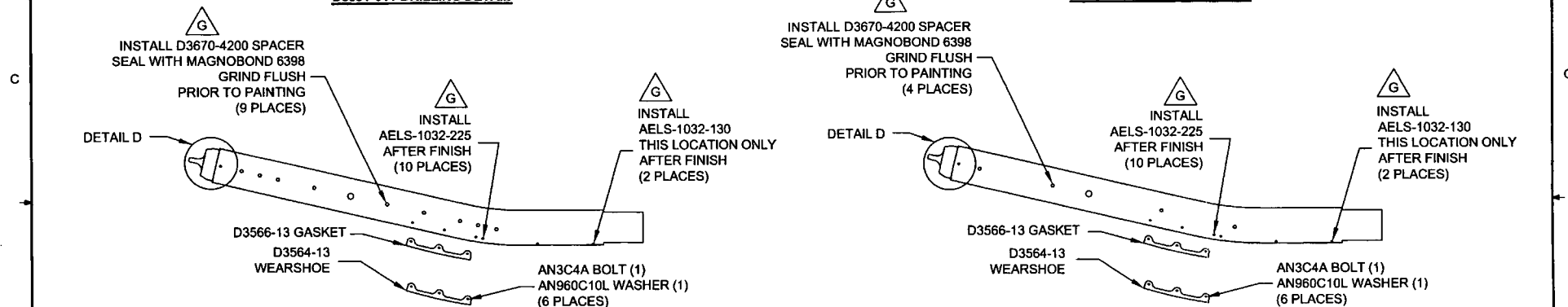
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| DRAWN | <i>GH</i> | PORT HADLOCK, WA | |
| CHECKED | <i>JC</i> | DRAWING NO. | REV. G |
| MFG. APPR. | <i>CE</i> | D3391 | SHEET 3 OF 8 |
| APPROVED | <i>MP</i> | TITLE | SCALE |
| DE APPR. | <i>MP</i> | 412 FLOAT SKIDTUBE | 1:10 |
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D3391-011 DRILLING DETAIL

D3391-021 DRILLING DETAIL



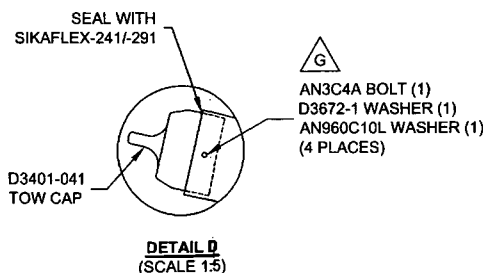
D3391-011 ASSEMBLY DETAIL

D3391-021 ASSEMBLY DETAIL

RELEASED
07.11.06

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

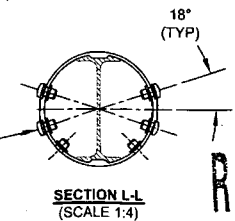
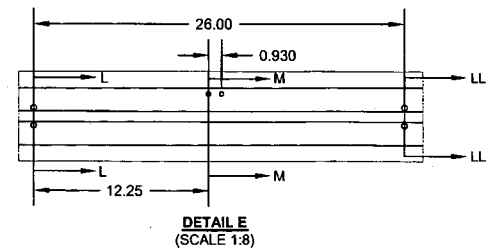
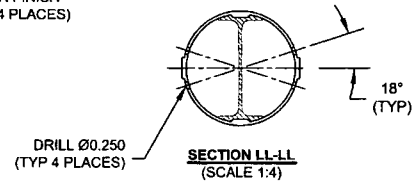
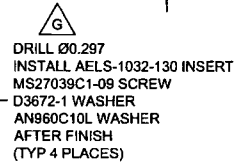
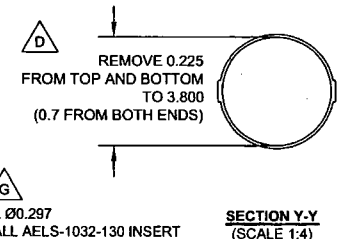
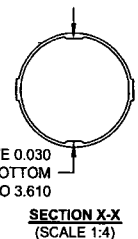
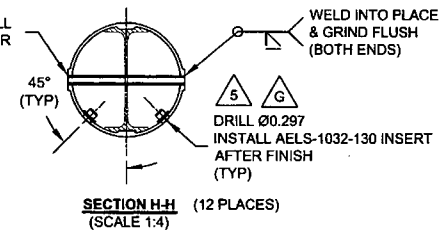
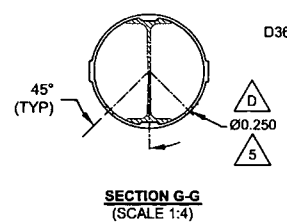
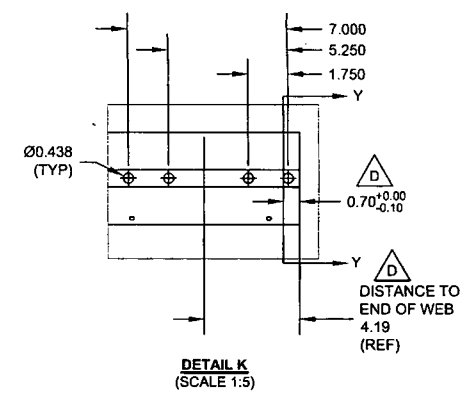
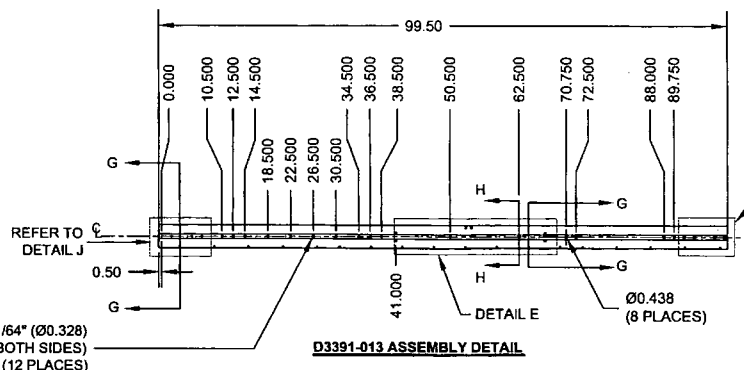
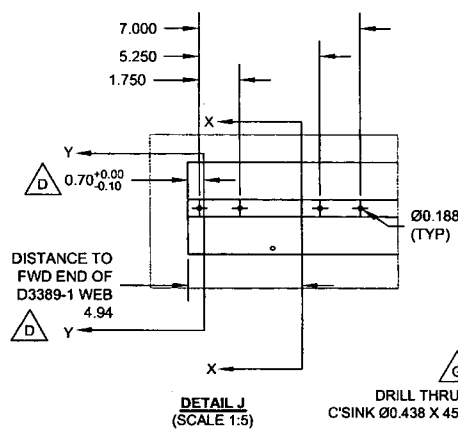
| QTY - 011 | QTY - 021 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | | D3391-011 | FWD TUBE ASSEMBLY |
| | X | D3391-021 | FWD TUBE ASSEMBLY |
| 1 | 1 | D6013-047 | FWD TUBE |
| 1 | 1 | D3401-041 | TOW CAP |
| 1 | 1 | D3564-13 | WEARSHOE |
| 1 | 1 | D3566-13 | GASKET |
| 9 | 4 | D3670-4200 | SPACER |
| 4 | 4 | D3672-1 | WASHER |
| 10 | 10 | AN3C4A | BOLT |
| 10 | 10 | AN960C10L | WASHER |
| 2 | 2 | AELS-1032-130 | INSERT |
| 10 | 10 | AELS-1032-225 | INSERT |



| | | |
|------------|----------|---|
| DESIGN | | DART AEROSPACE USA, INC |
| DRAWN | | PORT HADLOCK, WA |
| CHECKED | | DRAWING NO. REV. G |
| MFG. APPR. | | D3391 SHEET 4 OF 8 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE 1:10 |
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8 7 6 5 4 3 2 1



D3391-013 MID TUBE ASSEMBLY PARTS LIST

| QTY -013 | PART NUMBER | DESCRIPTION |
|----------|---------------|-------------------|
| X | D3391-013 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 12 | D3681-1 | SPACER |
| 4 | D3672-1 | WASHER |
| 4 | D3672-3 | WASHER |
| 24 | AELS-1032-130 | INSERT |
| 4 | ALS4-428-165 | INSERT |
| 4 | AN960C10L | WASHER |
| 4 | AN960C416L | WASHER |
| 4 | MS27039C1-09 | SCREW |
| 4 | MS27039C4-08 | SCREW |

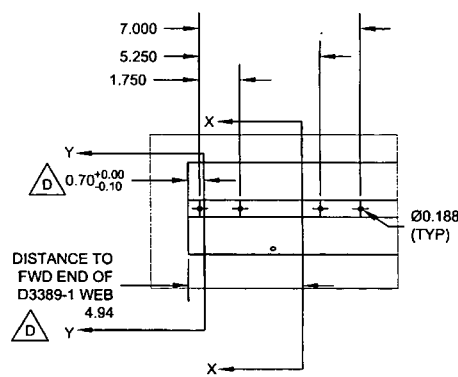
D3391-013 MID TUBE ASSEMBLY
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
WELDING PER DART QSI 004

| DESIGN | | DART AEROSPACE USA, INC | |
|------------|----------|---|--------------|
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | DE | DRAWING NO. | REV. G |
| MFG. APPR. | 1 | D3391 | SHEET 5 OF 8 |
| APPROVED | 1 | TITLE | SCALE |
| DE APPR. | 1 | 412 FLOAT SKIDTUBE | 1:20 |
| DATE | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |

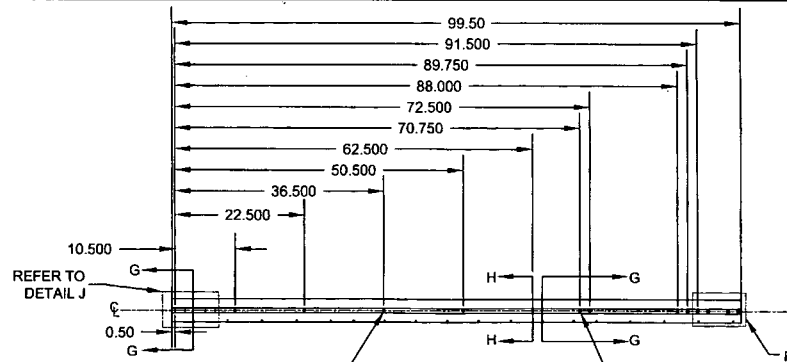
RELEASED
07.11.07

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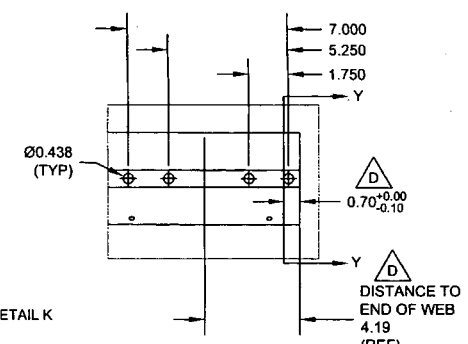
8 7 6 5 4 3 2 1



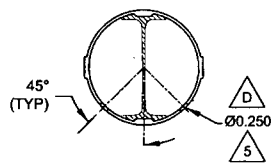
DETAIL J
(SCALE 1:5)



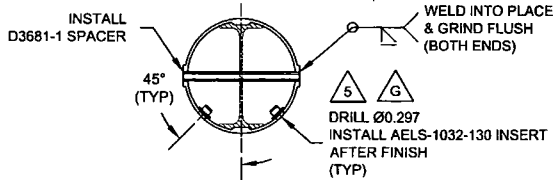
D3391-023 ASSEMBLY DETAIL



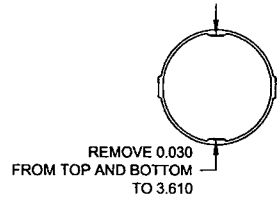
DETAIL K
(SCALE 1:5)



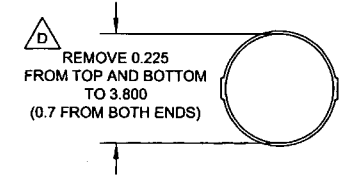
SECTION G-G
(SCALE 1:4)



SECTION H-H
(SCALE 1:4)



SECTION X-X
(SCALE 1:4)



SECTION Y-Y
(SCALE 1:4)

D3391-023 MID TUBE ASSEMBLY PARTS LIST

| QTY - 023 | PART NUMBER | DESCRIPTION |
|-----------|---------------|-------------------|
| X | D3391-023 | MID TUBE ASSEMBLY |
| 1 | D2500-1-100 | EXTRUSION |
| 1 | D3389-1 | WEB |
| 5 | D3681-1 | SPACER |
| 20 | AELS-1032-130 | INSERT |

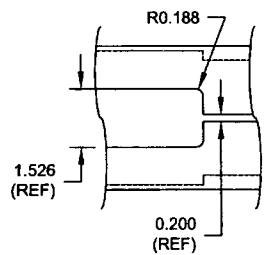
RELEASED
07-11-06/11

| | | | |
|------------|----------|---|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | DE | PORT HADLOCK, WA | |
| CHECKED | g | DRAWING NO. | REV. G |
| MFG. APPR. | g | D3391 | SHEET 6 OF 8 |
| APPROVED | g | TITLE | SCALE |
| DE APPR. | g | 412 FLOAT SKIDTUBE | 1:20 |
| DATE | 07.07.31 | COPYRIGHT © 2005 BY DART AEROSPACE USA, INC | |

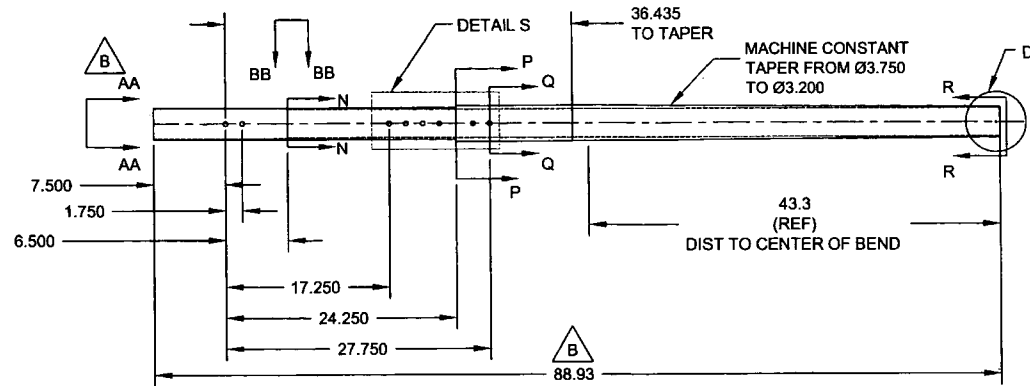
D3391-023 MID TUBE ASSEMBLY
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
WELDING: PER DART QSI 004

WORK ORDER
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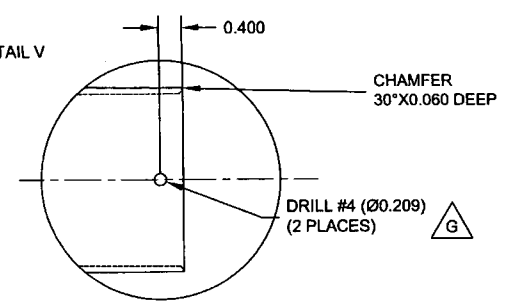
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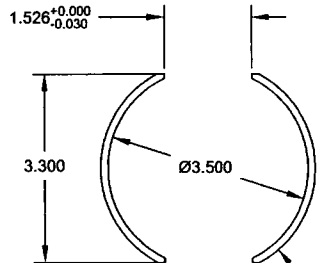
VIEW BB-BB
(SCALE 1:3)



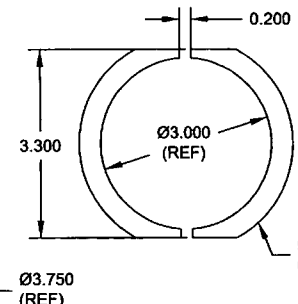
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



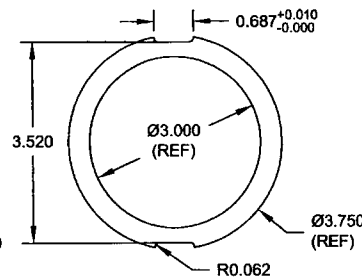
DETAIL V
(SCALE 1:2)



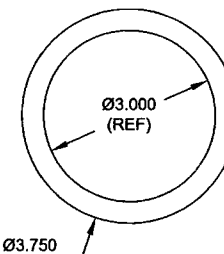
SECTION AA-AA
(SCALE 1:2)



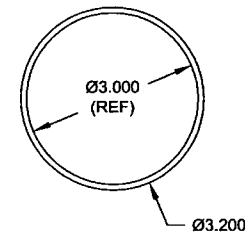
SECTION N-N
(SCALE 1:2)



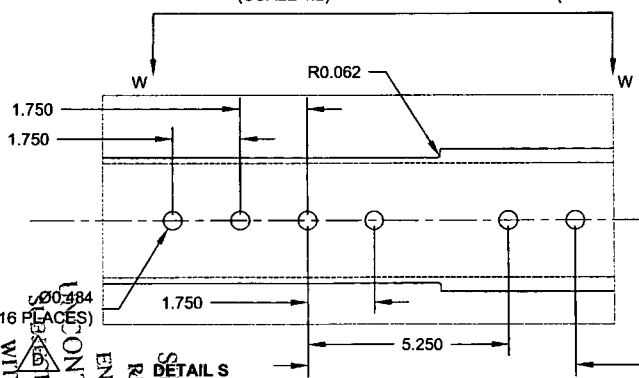
SECTION P-P
(SCALE 1:2)



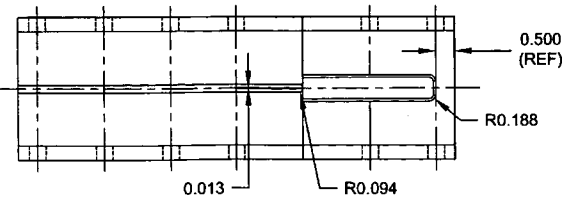
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)

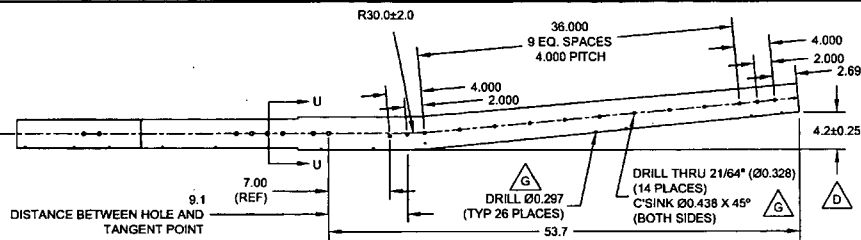


VIEW W-W
(SCALE 1:3)

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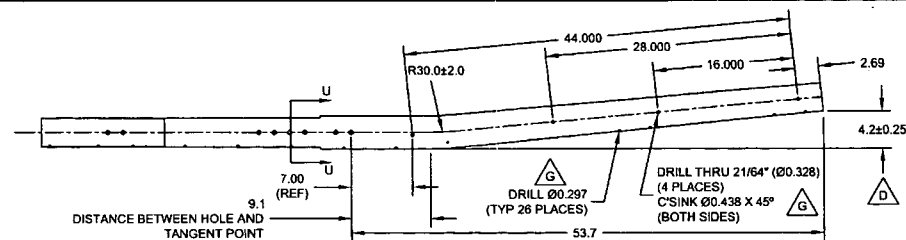
| | | |
|------------|----------|---|
| DESIGN | | DART AEROSPACE USA, INC |
| DRAWN | | PORT HADLOCK, WA |
| CHECKED | | DRAWING NO. REV. G |
| MFG. APPR. | | D3391 SHEET 7 OF 8 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | 412 FLOAT SKIDTUBE 1:12 |
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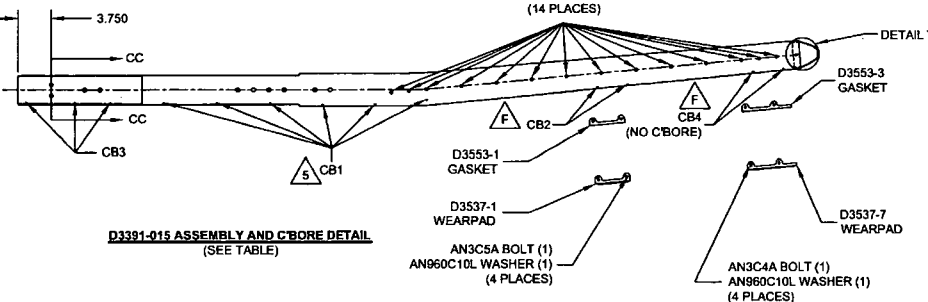
D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
(14 PLACES)

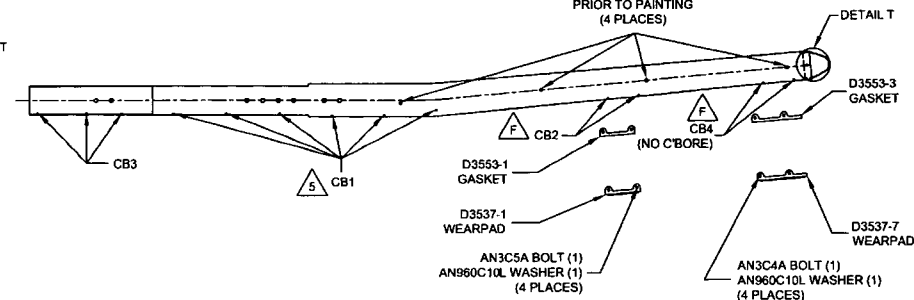


D3391-025 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
(4 PLACES)



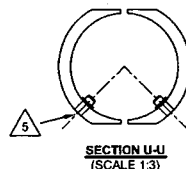
D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)



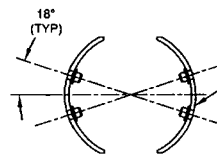
D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

| QTY - 015 | QTY - 025 | PART NUMBER | DESCRIPTION |
|-----------|-----------|---------------|-------------------|
| X | | D3391-015 | AFT TUBE ASSEMBLY |
| | X | D3391-025 | AFT TUBE ASSEMBLY |
| 1 | 1 | D6014-090 | AFT TUBE |
| 1 | 1 | D2846 | AFT CAP |
| 1 | 1 | D3537-1 | WEARPAD |
| 1 | 1 | D3537-7 | WEARPAD |
| 1 | 1 | D3553-1 | GASKET |
| 1 | 1 | D3553-3 | GASKET |
| 14 | 4 | D3670-4200 | SPACER |
| 2 | 2 | D3672-1 | WASHER |
| 14 | 14 | AELS-1032-130 | INSERT |
| 12 | 12 | AELS-1032-225 | INSERT |
| 4 | 4 | ALS4-428-165 | INSERT |
| 6 | 6 | AN3C4A | BOLT |
| 4 | 4 | AN3C5A | BOLT |
| 10 | 10 | AN960C10L | WASHER |

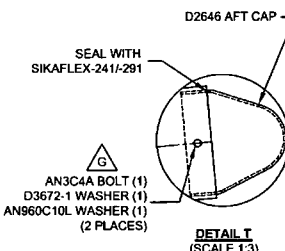


SECTION U-U
(SCALE 1:3)



SECTION CC-CG
(SCALE 1:3)

DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



DETAIL T
(SCALE 1:3)

RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

| HOLES MARKED | QTY D3391-015 | QTY D3391-025 | C'BORE | P/N |
|--------------|---------------|---------------|----------------|---------------|
| CB1 | 12 | 12 | Ø0.430 X 0.170 | AELS-1032-225 |
| CB2 | 4 | 4 | Ø0.430 X 0.170 | AELS-1032-130 |
| CB3 | 6 | 6 | Ø0.430 X 0.040 | AELS-1032-130 |
| CB4 | 4 | 4 | NONE | AELS-1032-130 |

| | | | |
|------------|----------|--|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | DC | PORT HADLOCK, WA | |
| CHECKED | JS | DRAWING NO. | REV. G |
| MFG. APPR. | AL | D3391 | SHEET 8 OF 8 |
| APPROVED | AL | TITLE | SCALE |
| DE APPR. | AL | 412 FLOAT SKIDTUBE | 1:12 |
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